ASAP

Work Order ID 108071 D3293-1 B108071 *108071* Page 1

October-07-13 9:10:35 AM

Item ID: D3293-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Doubler For Interior Window For -111

Start Date: 10/07/13 **Start Qty:** 8.00 16 *8* **Cust Item ID:**

Required Date: 10/07/13 **Req'd Qty:** 8.00 *8* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** MLJ **Date:** 13-10-07 **Tooling:** **Date:** **Stop** *NR2*

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3293	B								
100		0.00							
100	FLOW WATER JET					16	0		JM 3-11-14
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3293 Dwg Rev: B								
2024 .080	Prog Rev: B								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110						16	0		JM 3-11-14
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

0

Work Order ID 108071

108071

October-07-13 9:10:35 AM

Item ID: D3293-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Doubler For Interior Window For -111

Start Date: 10/07/13 **Start Qty:** 8.00 *8*
Required Date: 10/07/13 **Req'd Qty:** 8.00 *8*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00				16			
120		DAS 27 9-89							
QC	**Memo**	0.00 B 11 20							
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00				16 MG 13-11-20			
150									
HandFinish	**Memo**	0.00							
Hand Finishing									
155	QC7-Inspect Chemical Conversion Coat	0.00				16 ϕ 13-11-20.			DAS 34 9-89
155									
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

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- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

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Work Order ID 108071

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October-07-13 9:10:35 AM

Item ID: D3293-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

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Start Date: 10/07/13 **Start Qty:** 8.00 *8*

Required Date: 10/07/13 **Req'd Qty:** 8.00 *8*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Black Sandtex(Ref 4.3-7) per QSI005 4.3	0.00				16	0	13-11-00	DAS 34 9-89
160									
Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: 2:40 OVEN TEMPERATURE: 820 FINISH TIME: 5:10								
170	QC3- Inspect Part Finish	0.00				16			DAS 27 9-89
170									
QC	**Memo**	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: ST211	0.00				16.		13-11-21.	DAS 26 9-89
180									
Packaging	**Memo**	0.00							
Packaging									

DQA: _____ Date: _____

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WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____

Part No. _____

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- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
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Process	☐									
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Unapproved	☐									

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Required Date: 10/07/13 **Req'd Qty:** 8.00 *8* **Customer:**
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Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	**Memo**	0.00							
Quality Control									

RM 13/11/21

pl 13-11-21

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

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- Prod. Eng. Coor. ☐
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- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
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Picklist Print

October-07-13 9:10:35 AM

Work Order ID: 108071

Parent Item: D3293-1

Parent Item Name: Doubler For Interior Window For -111

Start Date: 10/07/13 **Required Date:** 10/07/13

Start Qty: 8.00 **Required Qty:** 8.00

Comments: IPP: A04.08.24New issueKJ/JLM
IPP Rev:B Now on Waterjet 06-11-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080 2024-T3 .080 sheet		Purchased	No			100	sf	103.1700	1.8264	~~15.380~~210	30.0	JMB-11-19	

Location	Loc Qty	Loc Code
MAT022	103.17	
123217	27.75	
125636	25.92	
M126161	49.5	

123217 x 8 = 15 SqFT.
125636 x 4 = 7.5 SqFT.
126161 x 4 = 7.5 SqFT.

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

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AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

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- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

DART AEROSPACE LTD	Work Order:	108071
Description: Doubler	Part Number:	D3293-1
Inspection Dwg: D3293 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

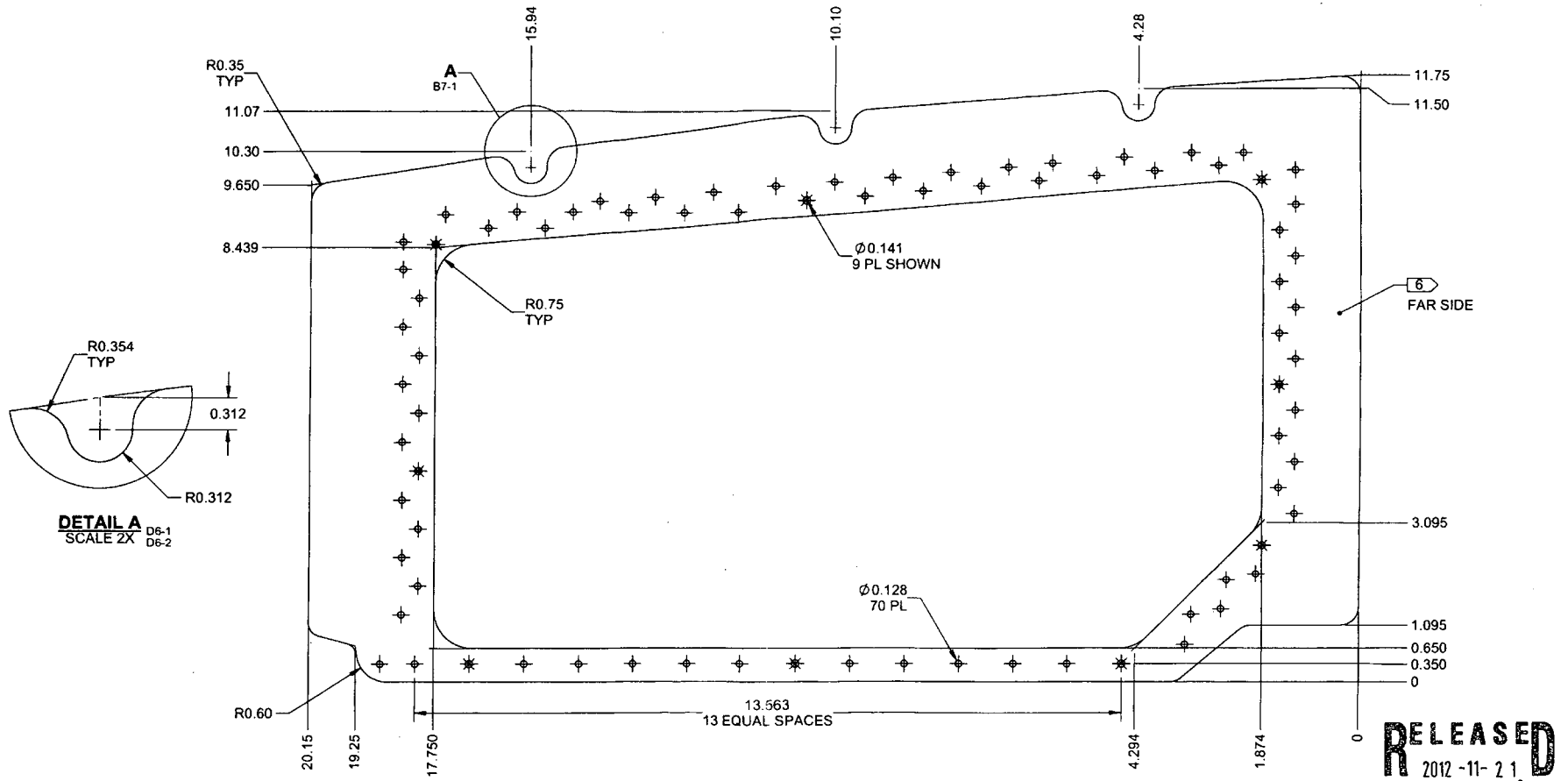
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.350	+/-0.010	0.352"	-		V	JM-01
0.650	+/-0.010	0.654"	-		V	
1.874	+/-0.010	1.974"	-		V	
Ø0.141	+0.005/-0.001	0.142"	-		V	
Ø0.128	+0.005/-0.001	0.129"	-		V	
17.750	+/-0.010	17.750"	-		T	JM-02
20.15	+/-0.030	20.15	-		T	
R0.350	+/-0.010	0.350"	-		RG	
R0.312	+/-0.010	0.312"	-		RG	
0.080	+/-0.010	0.079"	-		V	

Measured by:	JM
Date:	13-11-19

Audited by:	DAS 27
Date:	13 11 20

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	08.10.09	0.080 dimension added	KJ/DD	
C	13.05.08	Dwg Rev updated	KJ	



DETAIL A
SCALE 2X D6-1 D6-2

RELEASED
2012 -11- 21

D3293-1 DOUBLER

REV.	DESCRIPTION	BY	DATE
B	ADD D3293-1B. REF. PAR12-223.	MB	12.11.15
A	NEW ISSUE	CP	04.06.28

NOTES:
1) MATERIAL: 2024-T3 SHEET, 0.080 THICK, PER QQ-A-250/4 OR AMS 4073 OR ASTM B209
(REF DART SPEC M2024T3S.080)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3293-1" AND B/N "BXXXXX" PER DART QSI 044 6.1
8) MAKE PER DWG FILE "D3293-1_REVB.DXF"

DESIGN	
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	12.11.15

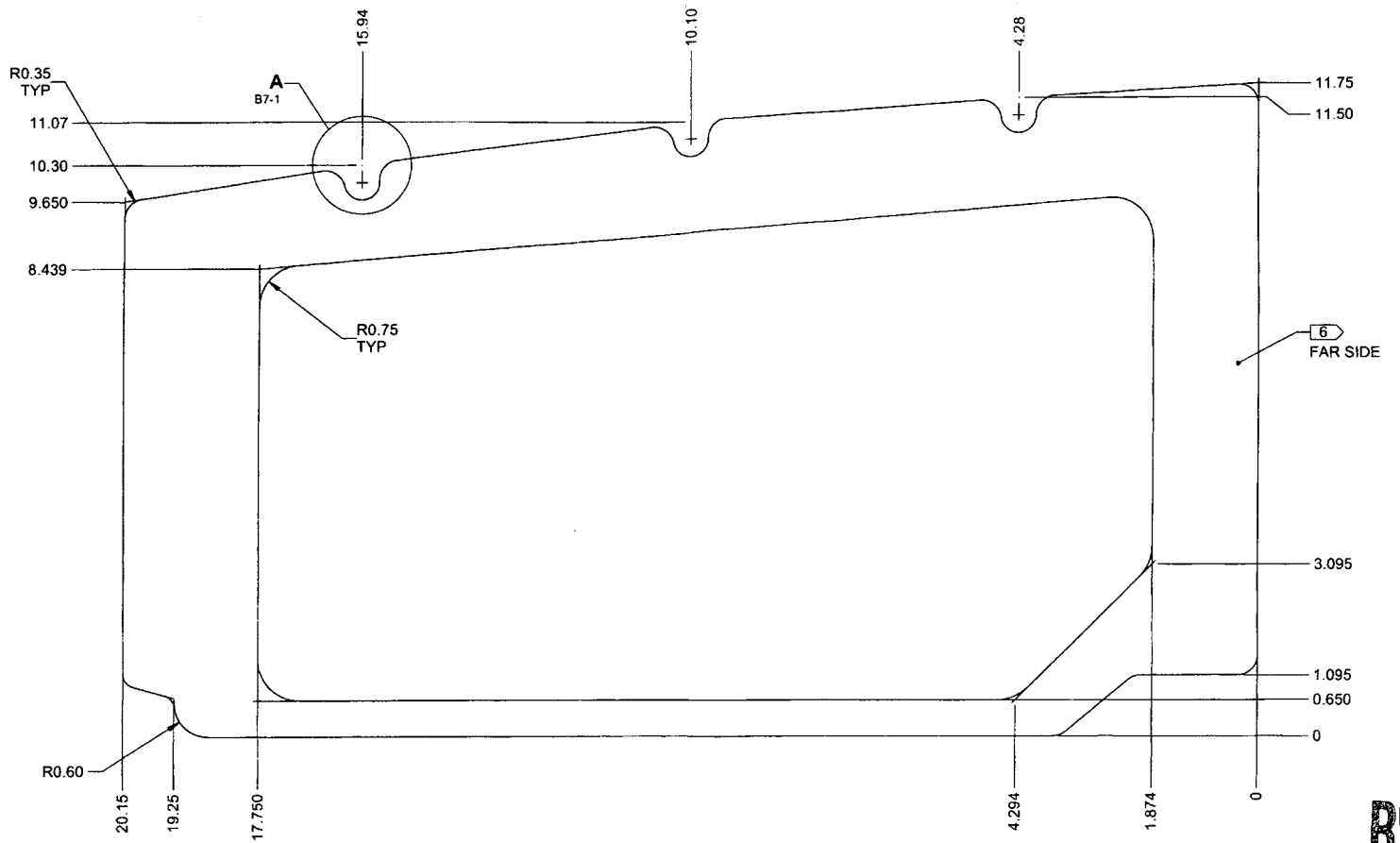
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3293 REV. B
SHEET 1 OF 2
TITLE DOUBLER
SCALE NTS

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108071 MLJ
13-10-07

108071



RELEASED
2012 -11- 21

B D3293-1B DOUBLER, BLANK

NOTES:
1) MATERIAL: 2024-T3 SHEET, 0.080 THICK, PER QQ-A-250/4 OR AMS 4073 OR ASTM B209
(REF DART SPEC M2024T3S.080)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3293-1B" AND B/N "BXXXXX" PER DART QSI 044 6.1
7) WEIGHT: 0.66 lbs
8) MAKE PER DWG FILE "D3293-1B_REVB.DXF"

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3293 — REV. B — SHEET 2 OF 2
MFG. APPR.		TITLE DOUBLER — SCALE NTS
APPROVED		
DE APPR.		
DATE 12.11.15		

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